

# Work Order ID 55343

January 13, 2010 11:03:08 AM

ASAP



Item ID: D3763-041

Accept



Setup Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3763	Rev B

100	Pick Kit	0.00							
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Packaging Memo 0.00

Packaging

*PK 10.01.13*

6



110	Large Fab	0.00							
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Large Fab Memo 0.00

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y 12-assemble as per dwg D3763 using locating pin DT9039 \*\*\*\*\*ensure locating pin is in 0.221" hole\*\*\*\*\* 13-weld as per dwg D3763 QSI004 Alum. rod Batch: mill 311

*PK 10.01.13*

6



120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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QC Memo 0.00

Quality Control

*PD 10.01.14* ⑥

**Work Order ID 55343**

January 13, 2010 11:03:09 AM



Page 2

Item ID: D3763-041

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly

Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SAD 10-01-14

(6)

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

SAD

0.00

10-01-14

(6)

Memo

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

SAD 10-01-14

(6)

Memo

0.00

# Picklist Print

January 13, 2010 11:03:08 AM

Page 1

Work Order ID: 55343

Parent Item: D3763-041

Parent Item Name: End Fitting Assembly


Start Date: 1/13/10

Required Date: 1/15/10

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec  
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC  
 IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3763-1		Manufactured	No			110	Each	23.0000	10.0000			
												
End Fitting												

*PE 10-01-13*

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST 23

54364 11

54433 12

D3763-3 Manufactured No 110 Each 6.0000 10.0000



Tube



*6*  
*PE 10-01-13*

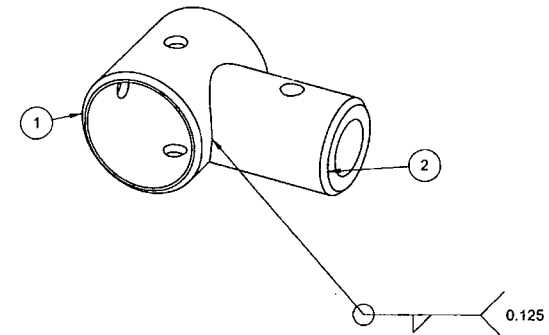
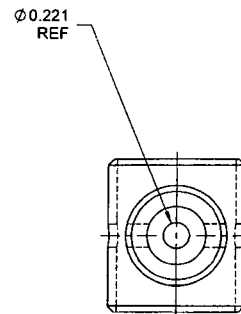
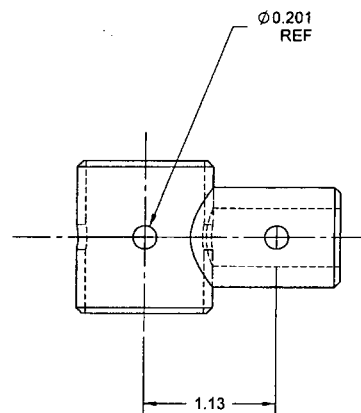
Warehouse Loc Qty Loc Code  
Location

Main Warehouse

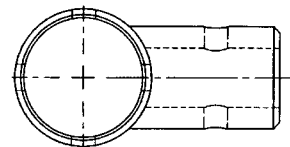
ST251 6

54436 6

*6*



W055343



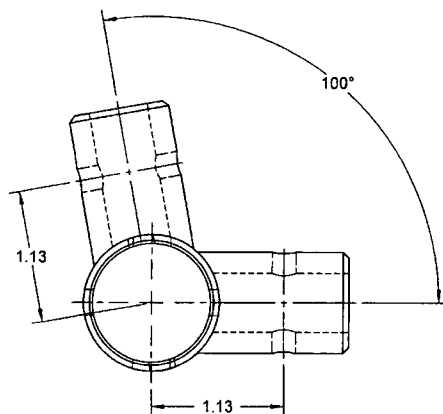
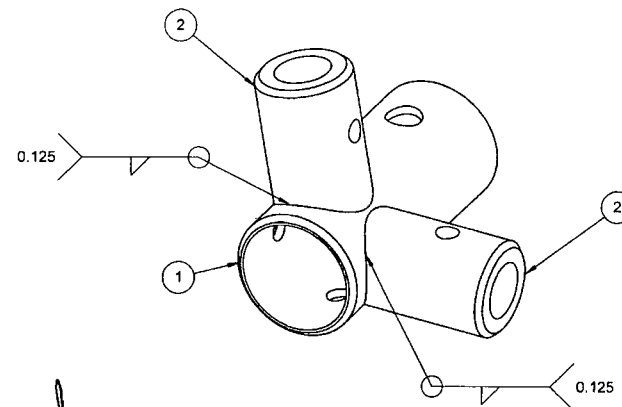
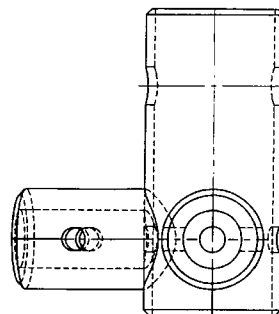
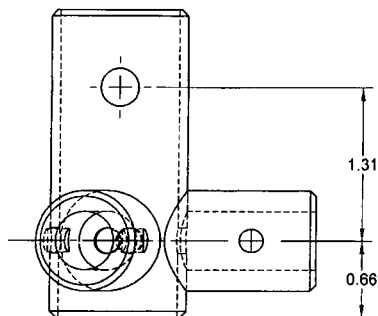
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

# **D3763-041 END FITTING ASSY**

RELEASED  
08.07.10

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.03 lbs
  - 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 1 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND BE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



W055343

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

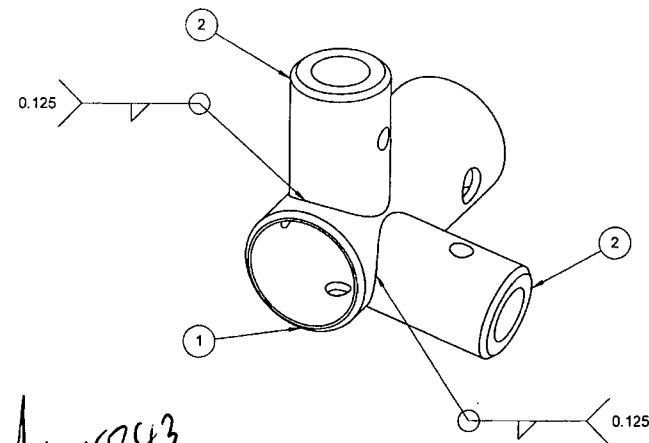
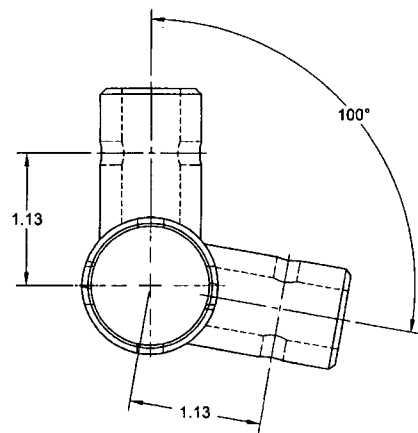
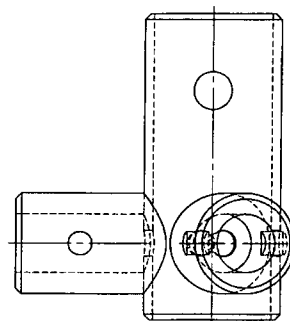
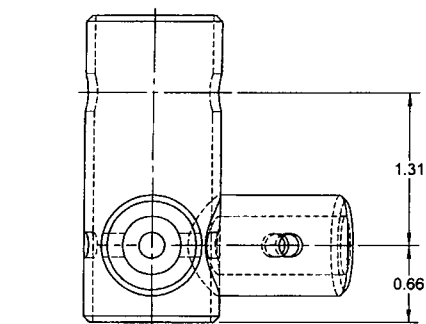
# **D3763-043 END FITTING ASSY, LH**

RELEASED  
08-01-2014

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. <b>D3763</b>	REV. B
MFG. APPR.			SHEET 2 OF 9
APPROVED		TITLE <b>END FITTING</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.06.23		



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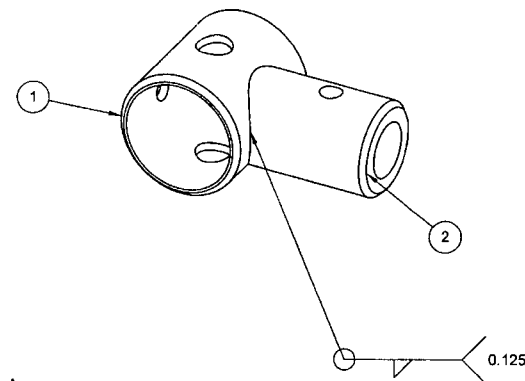
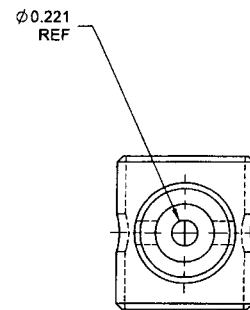
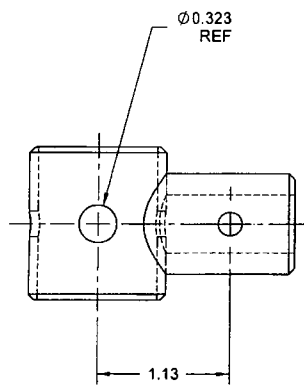
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

# **D3763-044 END FITTING ASSY, RH**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.05 lbs
  - 8) WELD: PER DART QSI 004

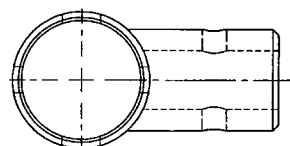
RELEASED  
08-07-10

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. <b>D3763</b>	REV. B
MFG. APPR.	HS	TITLE <b>END FITTING</b>	SHEET 3 OF 9
APPROVED	HS	DATE <b>08.06.23</b>	SCALE NTS
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al055343

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	TUBE	1
2	D3763-1	FITTING	1







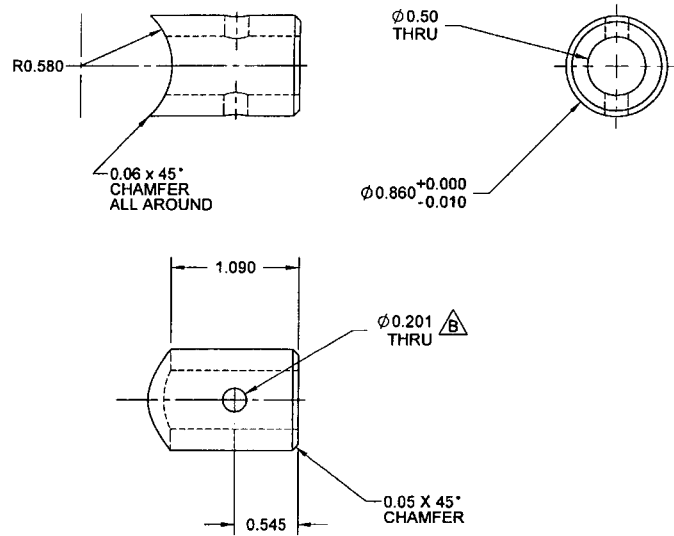
**D3763-045 END FITTING ASSY**

RELEASED  
08-07-10/11/12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 4 OF 9
APPROVED		TITLE	SCALE
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al 055343

**D3763-1 FITTING**

RELEASED  
08-07-10 TPD

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.02 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3763</b>	SHEET 5 OF 9
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8 7 6 5 4 3 2 1

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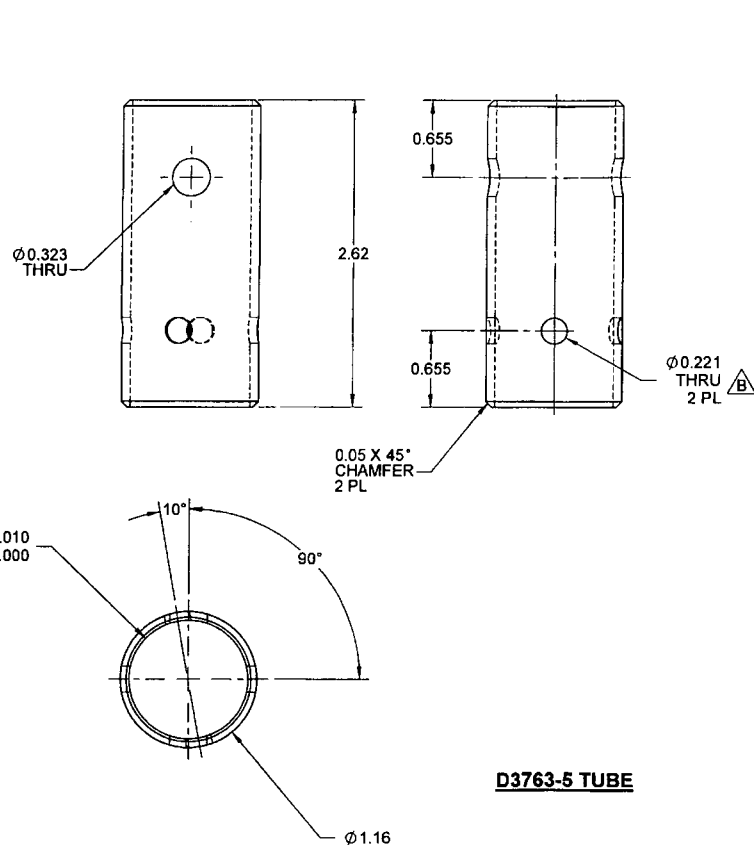
C

B

B

A

A



**D3763-5 TUBE**

55343

RELEASED  
68-07-10 14

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO. <b>D3763</b>	REV. B
MFG. APPR.		TITLE	SHEET 7 OF 9
APPROVED		<b>END FITTING</b>	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

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1

D

C

B

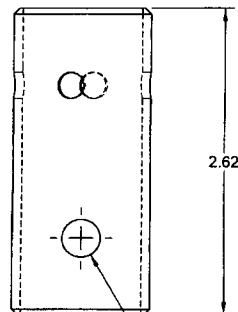
A

D

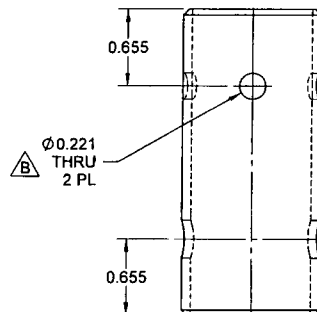
C

B

A

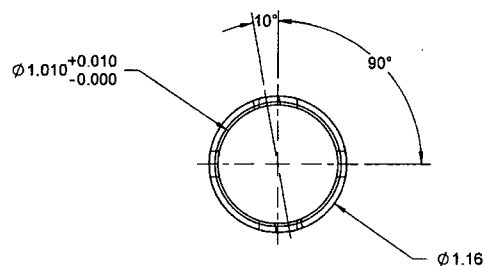
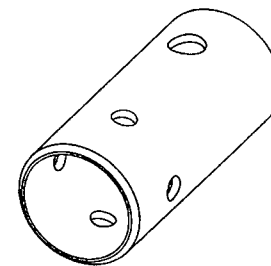


$\varnothing 0.323$   
THRU



0.05 X 45°  
CHAMFER  
2 PL

$\varnothing 0.221$   
THRU  
2 PL




**D3763-6 TUBE**

WV  
55343

RELEASED  
08-07-23

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3763</b>	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>END FITTING</b>	NTS
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8

7

6

5

4

3

2

1

Ø 1.010<sup>+0.010</sup>  
-0.000

Ø 1.16

Ø 0.221  
THRU


0.66

1.31

0.05 X 45°  
CHAMFER  
2 PL

Ø 0.323  
THRU

0.66

**D3763-7 TUBE** 

WU 554B

RELEASED  
11-08-07-10

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8  
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3763</b>	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>END FITTING</b>	NTS
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